

Work Order ID 111856-2

January-23-14 2:40:49 PM

111856

Page 1

Item ID: E4706-041
Revision ID:
Item Name: Support Assembly

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 24/01/2014 Start Qty: 5.00
Required Date: 28/02/2014 Req'd Qty: 5.00

5
5

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: MA Date: 14-01-23
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
E4706	

100

0.00

100

Purchasing

Purchasing

Memo

Purchasing

Issue P/O: 22776

Supplier: WEJAY.

Machine as per Dwg E4706-1

Conformity sheet required

0.00

CL 14/01/28 5

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

14/4/14 (1)

Work Order ID 111856

January-23-14 2:40:49 PM

111856

Page 2

Item ID: E4706-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support Assembly

Start Date: 24/01/2014 Start Qty: 5.00

5

Cust Item ID:

Required Date: 28/02/2014 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Quality Control

Memo

0.00

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Hand Finishing

Memo

0.00

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Quality Control

Memo

0.00

LPI / PRESSURE WASH

P/O: 23701

C214104108

QC6

27
9-89

4/4/10

①

Work Order ID 111856

January-23-14 2:40:49 PM

111856

Page 3

Item ID: E4706-041

Revision ID:

Item Name: Support Assembly

Start Date: 24/01/2014 Start Qty: 5.00

Required Date: 28/02/2014 Req'd Qty: 5.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

141

141

SprayPaint

Spray Painting

Memo

PRIME AS PER DWG

128049

0.00

0.00

142

142

QC

Quality Control

QC14- Inspect Spray Paint

Memo

0.00

0.00

143

143

Small Fab

Small Fab

Memo

INSERT BUSHING AS PER DWG

0.00

0.00

CP 14-04-08

514104109

IX

14/04/09

DAS
36
9-89

Work Order ID 111856

January-23-14 2:40:49 PM

111856

Page 2

Item ID: E4706-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support Assembly

Start Date: 24/01/2014 Start Qty: 5.00

5

Cust Item ID:

Required Date: 28/02/2014 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

144

QC5- Inspect part completeness to step on W/O

0.00

144

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location:

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

W 14.04.10

APR 10 2014

Picklist Print

January-23-14 2:40:54 PM

Page 1

Work Order ID: 111856

111856

Parent Item: E4706-041

F4706-041

Parent Item Name: Support Assembly

Start Date: 24/01/2014

Required Date: 28/02/2014

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 14-01-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
E4706-1P		Purchased	No				Each	0.0000		5			
F4706-1P									**				
Support Bracket													
NAS77A5-025		Purchased	No				Each	4.0000		5			
NAS77A5-025									**				
Bushing													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST277			4						
					123039		4						
NAS77A6-031		Purchased	No				Each	4.0000		5			
NAS77A6-031									**				
Bushing													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST277			4						
					123039		4						
NAS77A7-025		Purchased	No				Each	4.0000		5			
NAS77A7-025									**				
Bushing													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST277			4						
					123039		4						
NAS77A8-031		Purchased	No				Each	4.0000		5			
NAS77A8-031									**				
Bushing													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST277			4						
					123039		4						

14/4/4 (1)

14/04/09 DAS 36 9-89

M128429 (1x)

14/04/09 DAS 36 9-89

M128749 (1x)

14/04/09 DAS 36 9-89

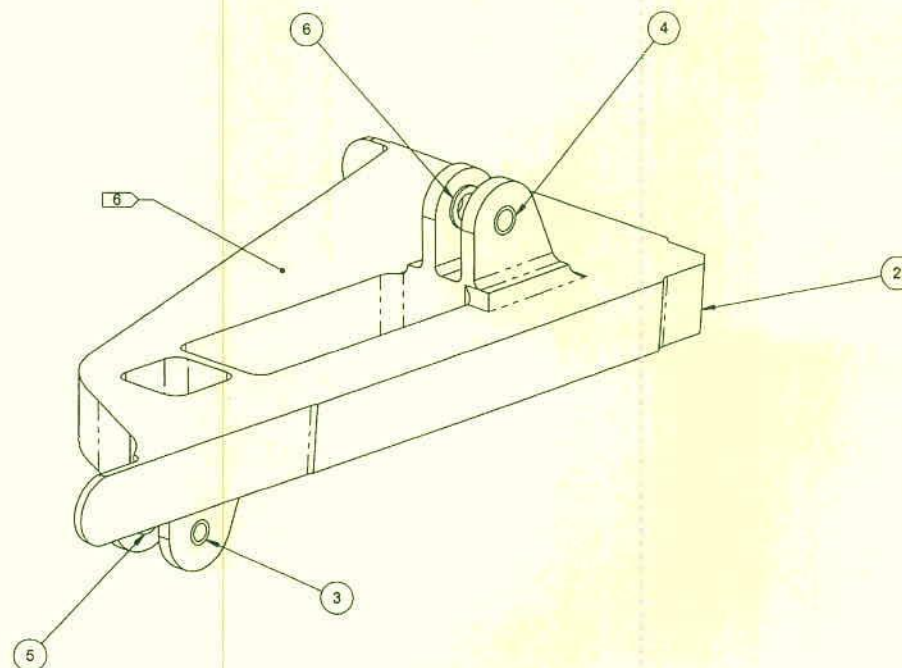
M128398 (1x)

14/04/09 DAS 36 9-89

M128749 (1x)



ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	E4706-041	SUPPORT ASSEMBLY
2	1	E4706-1	SUPPORT BRACKET
3	1	NAS77A5-025	BUSHING
4	1	NAS77A6-031	BUSHING
5	1	NAS77A7-025	BUSHING
6	1	NAS77A8-031	BUSHING



111856 MP
14-01-23

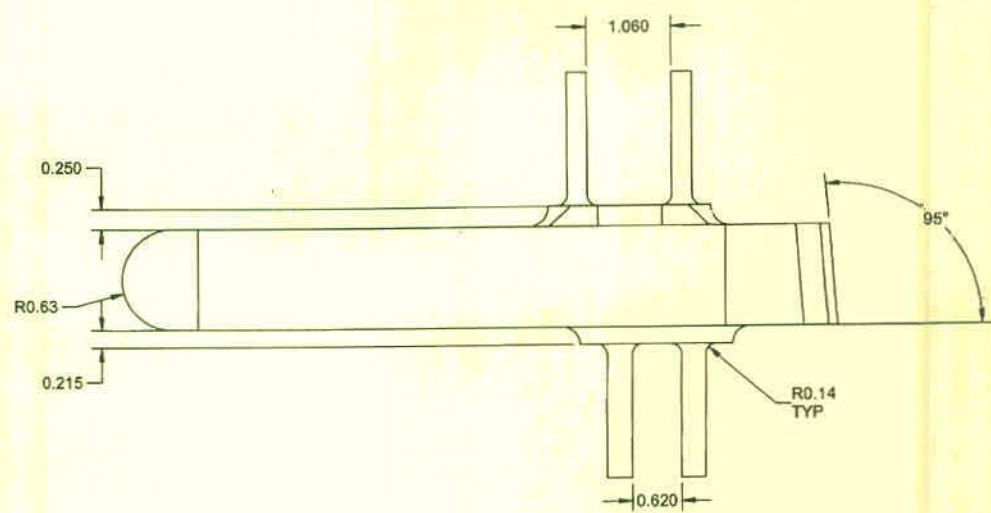
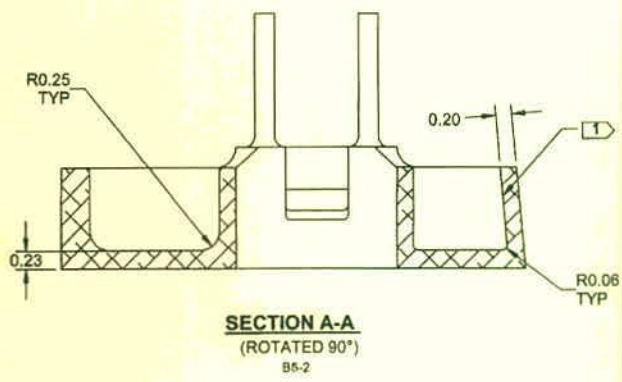
E4706-041 SUPPORT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.93 lbs

RELEASED
2013-11-23
MP

A	NEW ISSUE	DC	12.08.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BC	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. A
MFG. APPR.	BC	E4706	SHEET 1 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SUPPORT ASSEMBLY	NTS
DATE	12.08.30	COPYRIGHT © 2012 BY EAGLE COPTERS LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED UNDER BUSINESS CONFIDENTIALITY IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR CHANGED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD.	

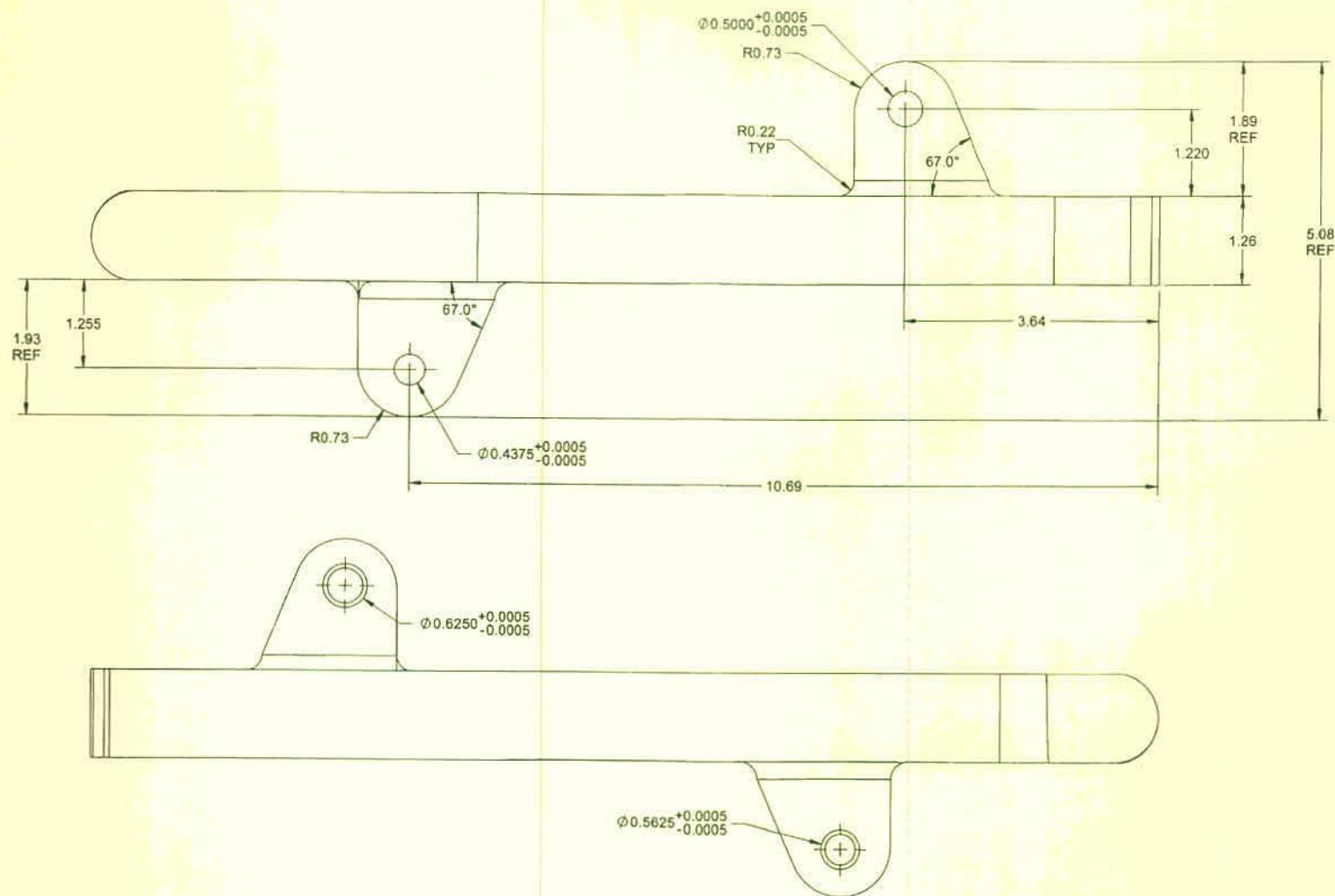


E4706-1 SUPPORT BRACKET
RIGHT VIEW

RELEASED
2013-11-28

NOTES:
1) CREATE RELIEF PARALLEL TO OUTSIDE FACE AT LOCATION SHOWN

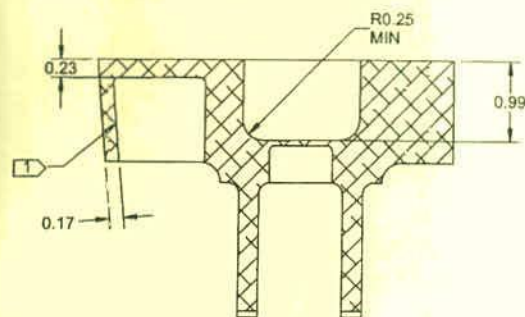
DESIGN	DC	EAGLE COPTERS LTD	
DRAWN	DC	CALGARY, ALBERTA, CANADA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DC	E4706	SHEET 3 OF 5
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	SUPPORT ASSEMBLY	NTS
DATE	12.08.30	COPYRIGHT © 2012 BY EAGLE COPTERS LTD	
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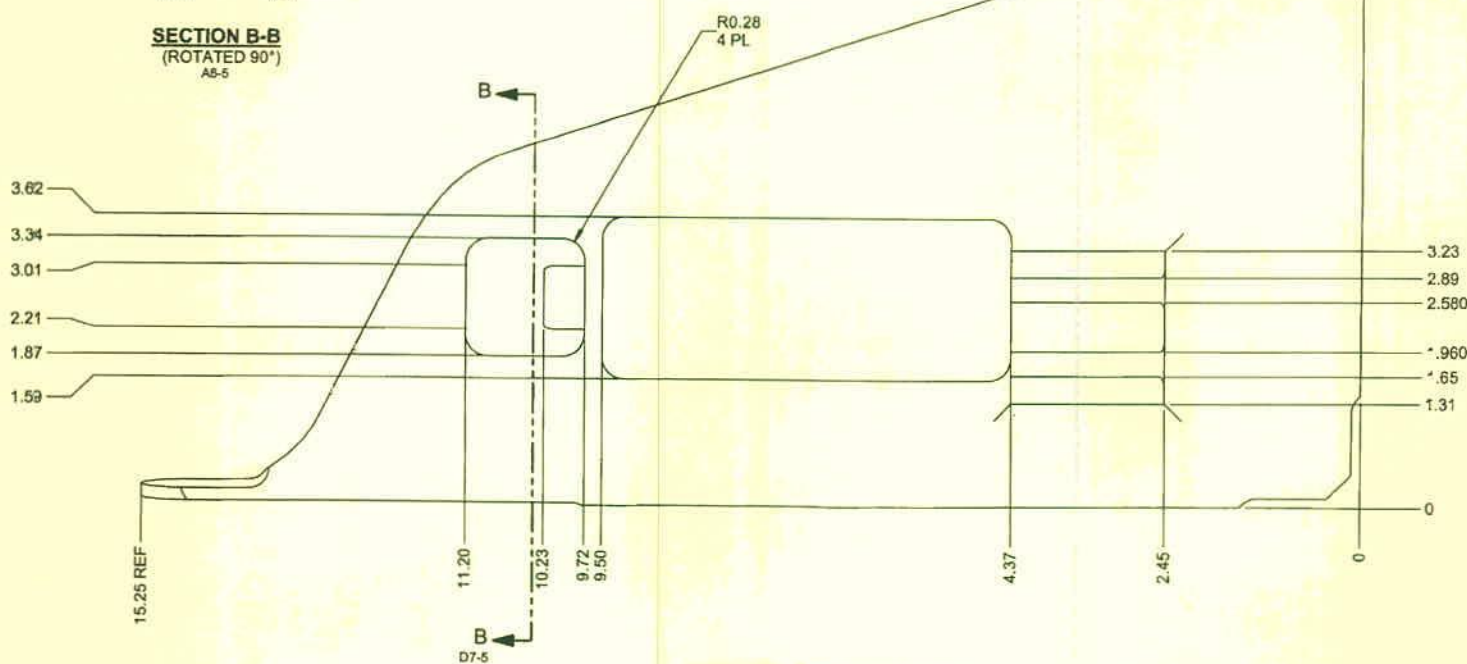
**E4706-1 SUPPORT BRACKET
SUPPLEMENTARY VIEWS**

DESIGN	DC	EAGLE COPTERS LTD	
DRAWN	DC	CALGARY, ALBERTA, CANADA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DC	E4706	SHEET 4 OF 5
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	SUPPORT ASSEMBLY	NTS
DATE	12.08.30	<small>COPYRIGHT © 2012 BY EAGLE COPTERS LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM EAGLE COPTERS LTD</small>	

RELEASED
2013-11-29
MP



SECTION B-B
(ROTATED 90°)
A8-5



E4706-1 SUPPORT BRACKET
BOTTOM VIEW

NOTES:
1) CREATE RELIEF PARALLEL TO OUTSIDE FACE AT LOCATION SHOWN

RECEIVED
2013-11-28

DESIGN	BC	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA DRAWING NO: E4706 TITLE SUPPORT ASSEMBLY COPYRIGHT © 2012 BY EAGLE COPTERS LTD <small>THIS DOCUMENT IS PREPARED AND CONTROLLED, AND IS THE PROPERTY OF THE COMPANY. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF THE COMPANY. IT IS TO BE DESTROYED WHEN NO LONGER REQUIRED.</small>	REV. A
DRAWN	BC		SHEET 6 OF 6
CHECKED	ES		SCALE
MFG. APPR.	20		NTS
APPROVED	21		
DE APPR.	#		
DATE	12.08.30		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22776

Purchase Order Date 1/24/2014

PO Print Date 1/28/2014

Page Number 1 of 1

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

2/1/14/28

Contact Name
Vendor Phone 613-384-1662

Ship To Contact
Ship To Phone
Ship Via: FedEx PI collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms COD
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pr
E4702-1P		Ladder	3/28/2014 Yes 3/24/2014		5.00 Each	\$1,910.00	\$9,550.

MACHINE AS PER DWG E4702 REV. A
B111857

QUOTATION NO. WJ-7672

Line Total: \$9,550.

E4706-1P Support Bracket 3/24/2014 Yes 3/24/2014

5.00
Each

\$2,330.00 \$11,650

MACHINE AS PER DWG E4706 REV. A
B111856

QUOTATION NO. WJ-7672

*rec'd 1/24/14
SP14-3-27*

Line Total: \$11,650

PO Total: \$21,200

PO Instructions: Procurement Quality Clauses
A004-FAA-PMA/TSO
A005-Right of Entry
A008-First Article Inspection (FAI) by seller,(Documentation sent to Dart Aerospace)
A011-Delegations-Supplier Verification of Dart Aerospace Product
A012-Chemical and Physical Reports
A016-Personnel Qualification
A026-Certificate of Material Conformance

CL M. Eugene



Packing Slip 36656A

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
TEL: 613-384-1662 FAX: 613-384-2997
www.wejay.com

S
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L
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T
O

S
H
I
P
T
O
Dart Aerospace
1870 Aberdeen Street
Hawkesbury, Ontario K6A 1K5

INVOICE DATE	YOUR ORDER NO.	DATE ORDERED	SHIPPED VIA
CUSTOMER CODE	PROV. LIC. NO.	Extra <input type="checkbox"/> Exempt <input type="checkbox"/>	TERMS

QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION	UNIT PRICE	AMOUNT
	—	1	1.000 support bracket as per drawing REV. 3 1000-1F		
<p align="center">RELEASE NOTE</p> <p>I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order.</p> <p>inspection Supervisor <u><i>Clifford</i></u> WMP 03</p> <p align="center">APRIL 2/14</p>					
<p>ORDER: COMPLETE <input type="checkbox"/> PARTIAL <input type="checkbox"/></p>				G.S.T. P.S.T.	TOTAL

RECEIVED BY _____

NO GOODS RETURNED WITH
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace	DATE: April 2, 2014		
	P.O.# PO22776		
	WEJAY JOB# 36656A		
<p>I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.</p>			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
E4706-1 'Support Assembly'	1	Machined complete per drawing req'ts.	E4706 / rev. A
Note: 1) Material Test Report attached -ref. 'Alcoa Inc' Lot# 554091 (Wejay TN# 030127-1). 2) 1st Article Dimensional Inspection report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

Clifford Smith
Authorized Q.A. Signatory

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per

Rob Woodall

Rob Woodall
Director of Manufacturing Davenport Works

Terrance Thom

Terrance Thom
Quality Assurance Manager

1626049

Ship Date

2013-10-03

0

B.L. No.

8817454

Invoice No.

00000

Alcoa No. Item

1000507868-10

DE-07868-10

P.O. No./Govt Contract No.

048669

Customer

Alcoa Item

G041130019R02

Page 1 of 2

Ship To:

Item Description

5.5 IN TK (+.130 -.130) X 48.5 IN W (+.3125 - 0.000) X 144.5 IN LN (+.5 -0.0) (N) A/T 7075- T7351 RECTANGLE MILL FINISH, USI 3MM DEAD ZONE REQ'D BOTH SIDES, SAWED. EXC MRK, TK, PROP, ST COR AMS-QQ-A- 250/12 IS 2007 AMS-STD-2154 REV A EXC MRK, TK, PROP, ST COR AMS4078 REV J EXC MRK, TK, PROP, ST COR ASTMB209 REV 10 ASTMB594 REV 13 BSS7055 REV A GAMPS9101 REV B PS21211 REV L ((MARKED)) KRAFT PAPER INTERLEAVED MAX GROSS SKID WGT: 5000-LB QUAN TOL +/-20 % USI CL A 3 MM COR 0239480 REV 02 CUST REQ 13-09- 30 *** W/E 13-10-05 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	560877	554091	3938	1	PC	47353

Notes for CQR: 0239480.2

THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I. PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154 REV A. PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS-STD-2154 REV A ALSO MEET THE REQUIREMENTS OF MIL-STD-2154.

CQR: 0239480.2 -Specification Limits

Temp	Dir	Max	Min	UTS KSI	TYS KSI	EL4D PCT
T7351	Long Transv.			54	38	5

T7351 Elec. Cond. (EC) % MIN 38.0 PCT

TN30127-1
J96 36656
Rec'd Mar 25/14

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

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Per:

Rob Woodall

Rob Woodall
Director of Manufacturing Davenport Works

Terrence Thoma

Terrence Thoma
Quality Assurance Manager

Page 2 of 2

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

1626049 Ship Date	0 B.L. No.	Invoice No.	Alcoa No. Item
2013-10-03	8817454	00000	1000507968-10 DP-07968-10
P.O. No./Govt Contract No.	Customer	Alcoa Item	
048669		G041130019R02	

CQR: 0239480.2 -Specification Limits (cont.)

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other Other	
									Each	Total Aluminum
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15
Min			1.2		2.1	0.18	5.1			REMAIN

Notes for Lot: 554091

MAX TYS-LT VALUE IS AN INTERNAL LIMIT. OK PER C.M.K. & B.L.G.

Lot: 554091 - Mechanical, Physical, Metallography, Quantometer Results

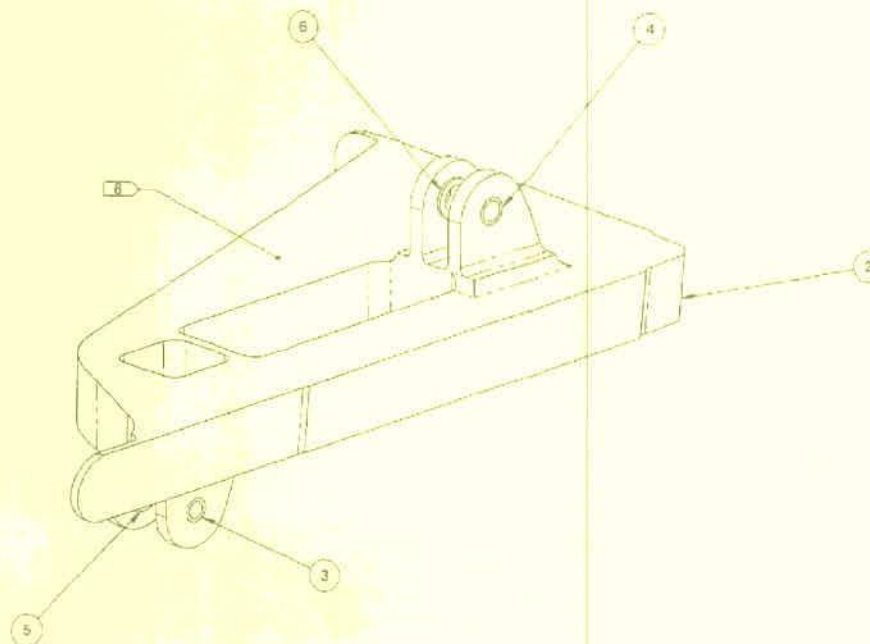
Temp	Dir	No-> Test	UTS KSI	TYS KSI	EL&D PCT
T7351	Long Transv.	2	64.2	51.8	9
			64.5	52.5	8.7

T7351 Elect Cond & IACS 40.8 40.5 PCT

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H9204081	Actuals	0.07	0.28	1.6	0.02	2.5	0.19	5.6	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	E4706-041	SUPPORT ASSEMBLY
2	1	E4706-1	SUPPORT BRACKET
3	1	NAS77A5-025	BUSHING
4	1	NAS77A6-031	BUSHING
5	1	NAS77A7-025	BUSHING
6	1	NAS77A8-031	BUSHING



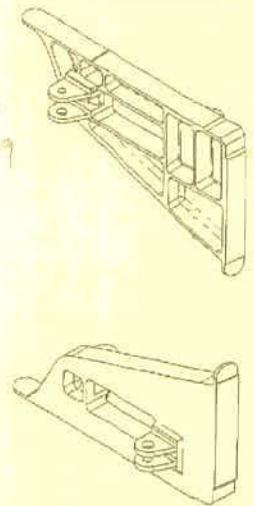
E4706-041 SUPPORT ASSEMBLY

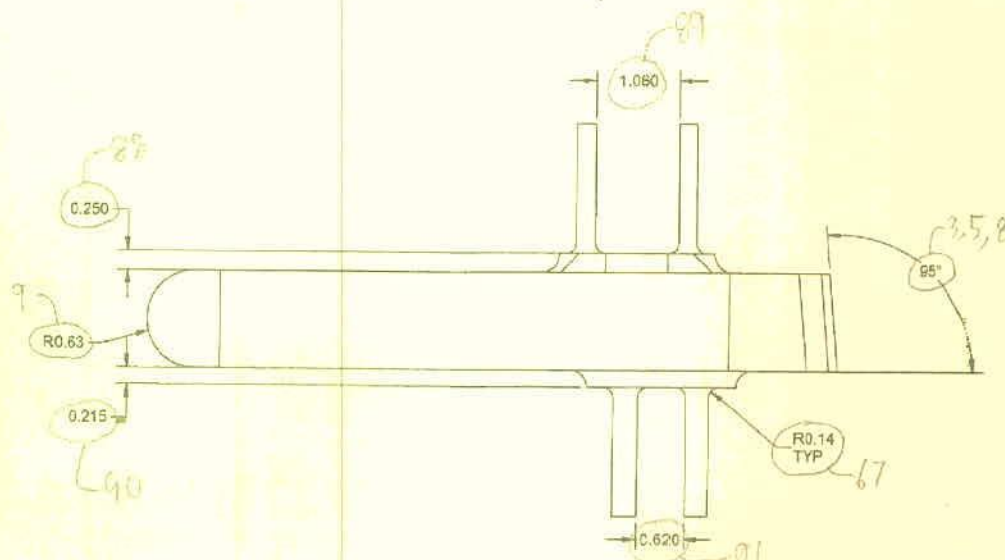
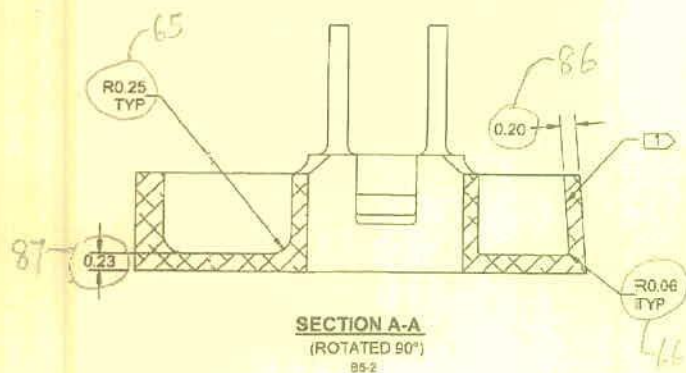
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHAPE EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.95 lbs

RELEASED
2013-05-13
MP

A	NEW ISSUE	DC	12.08.30
REV	DESCRIPTION	BY	DATE
DESIGN	DC	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	DC		
CHECKED	DC	DRAWING NO	REV. A
MFG. APPR.	DC	E4706	SHEET 1 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	★	SUPPORT ASSEMBLY	HTS
DATE	12.08.30	COPYRIGHT © 2012 BY EAGLE COPTERS LTD. THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL. NO DISSEMINATION TO ANY OTHERS WITHOUT THE APPROPRIATE AUTHORITY FROM EAGLE COPTERS LTD.	





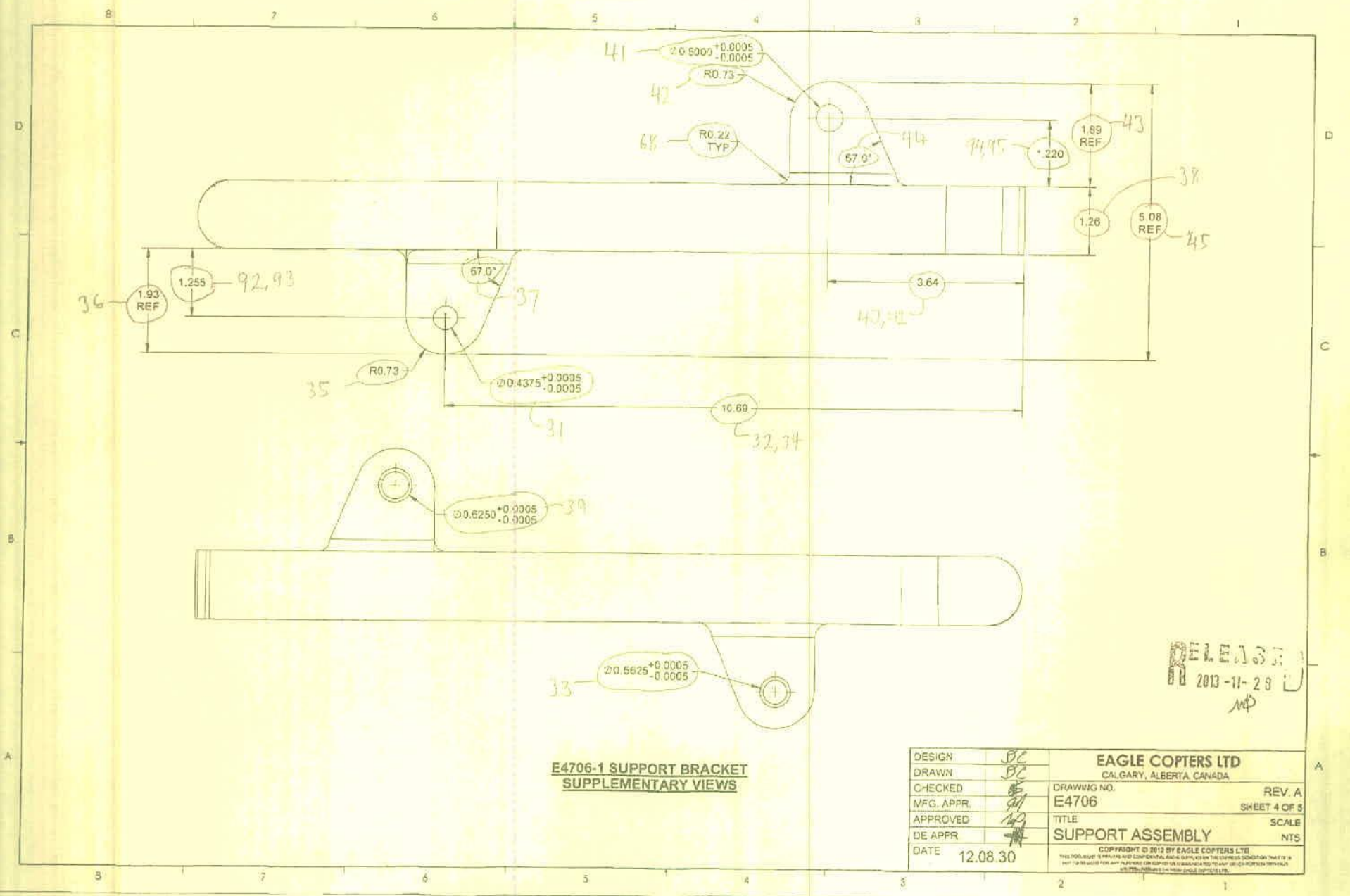
NOTES:
1) CREATE RELIEF PARALLEL TO OUTSIDE FACE AT LOCATION SHOWN

DESIGN	DC
DRAWN	DC
CHECKED	DC
MFG. APPR.	DC
APPROVED	DC
DE APPR.	DC
DATE	12.08.30

EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWING NO. E4706	REV. A
TITLE SUPPORT ASSEMBLY	SHEET 3 OF 5
SCALE NTS	

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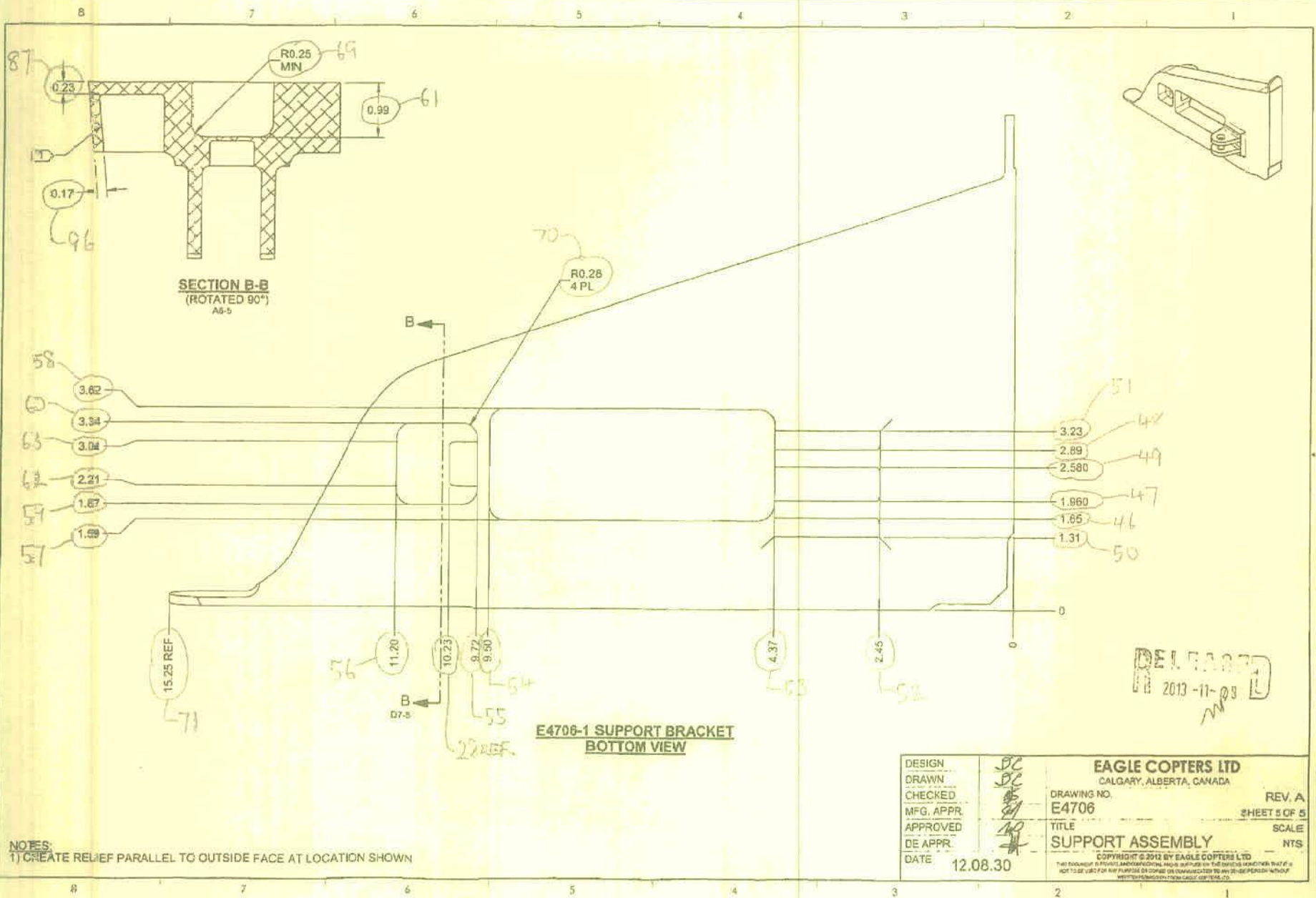
RELEASED
2013-11-21



E4706-1 SUPPORT BRACKET
SUPPLEMENTARY VIEWS

DESIGN	BC	EAGLE COPTERS LTD	
DRAWN	BC	CALGARY, ALBERTA, CANADA	
CHECKED	BC	DRAWING NO.	REV. A
MFG. APPR.	BC	E4706	SHEET 4 OF 8
APPROVED	BC	TITLE	SCALE
DE APPR	BC	SUPPORT ASSEMBLY	NTS
DATE	12.08.30	COPYRIGHT © 2012 BY EAGLE COPTERS LTD	

RELEASED
2013-11-28
MP





Customer Dart Aerospace

Customer P.O. PO22776

Drawing # E4706

Drawing rev A

Part Number D4706-1

E.C.O. -

Part Name Support Bracket

Material Alum. Alloy 7075-T7351 per ASTM B209

Serial # 005

Inspected by Cliff Smith

Job # 36656

Signature:



Overall Result

All Characteristics: 64
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Comment: Side 1

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<-- -->
■ Datum Face 1 Flat ref	GDT Flat	0.0011	0.0000	0.0050		0.0011	-
■ 1 2_D2	Y	8.9488	8.9500	0.0300	-0.0300	-0.0012	-
■ 2 2_D2	Y	-8.8389	-8.8400	0.0300	-0.0300	0.0011	-
■ 3 3_C1	A	94.9975	95.0000	0.5000	-0.5000	-0.0025	-
■ 4 2_D2	Y	8.8384	8.8400	0.0300	-0.0300	-0.0016	-
■ 5 3_C1	A	95.0025	95.0000	0.5000	-0.5000	0.0025	-
■ 6 2_D8	Y	8.9189	8.9201	0.0300	-0.0300	-0.0012	-
■ 7 2_D8	Y	8.8093	8.8099	0.0300	-0.0300	-0.0006	-
■ 8 3_C2	A	95.0106	95.0000	0.5000	-0.5000	0.0106	-
■ 9 3_C5	R	0.6286	0.6300	0.0300	-0.0300	-0.0014	-
■ 10 2_D2	X	-0.1146	-0.1200	0.0300	-0.0300	0.0054	-
■ 11 2_D3	X	-0.4156	-0.4200	0.0300	-0.0300	0.0044	-
■ 12 2_D3	X	-1.5045	-1.5100	0.0300	-0.0300	0.0055	-
■ 13 2_D6	X	-9.7522	-9.7500	0.0300	-0.0300	-0.0022	-
■ 14 2_B8	ResEle	-15.2487	-15.2500	0.0300	-0.0300	0.0013	-
■ 15 2_D8	Y	8.6516	8.6500	0.0300	-0.0300	0.0016	-
■ 16 2_B2	Y	0.9499	0.9500	0.0300	-0.0300	-0.0001	-
■ 18 2_D2	Y	8.5226	8.5200	0.0300	-0.0300	0.0026	-
■ 19 2_D2	Y	8.5227	8.5200	0.0300	-0.0300	0.0027	-
■ 20 2_B6	X	-9.4993	-9.5000	0.0300	-0.0300	0.0007	-
■ 21 2_B6	X	-11.4175	-11.4200	0.0300	-0.0300	0.0025	-
■ 22 2_C8	Y	5.5624	5.5600	0.0300	-0.0300	0.0024	-
■ 23 2_C8	Y	5.8099	5.8100	0.0300	-0.0300	-0.0001	-
■ 24 2_D8	Y	6.8724	6.8700	0.0300	-0.0300	0.0024	-
■ 25 2_D8	Y	7.1198	7.1200	0.0300	-0.0300	-0.0002	-
■ 25 2_C8	Y	5.9442	5.9450	0.0100	-0.0100	-0.0008	-
■ 26 2_D8	Y	6.7427	6.7450	0.0100	-0.0100	-0.0023	-
■ 27 2_D6	X	-9.7234	-9.7200	0.0300	-0.0300	-0.0034	-
■ 28 2_D6	X	-10.2282	-10.2300	0.0600	-0.0600	0.0018	-
■ 29a 2_D4	X	-4.3630	-4.3700	0.0300	-0.0300	0.0070	-
■ 29b 2_D4	X	-4.3650	-4.3700	0.0300	-0.0300	0.0050	-
■ 29c 2_D4	X	-4.3627	-4.3700	0.0300	-0.0300	0.0073	-

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
23 Perp to body surf ref	GDT Perp	0.0015	0.0000	0.0050		0.0015	-
24 Parallel to 23 ref	GDT Par	0.0018	0.0000	0.0050		0.0018	-
30a 3_C8	Z	-1.0343	-1.0400	0.0300	-0.0300	0.0057	-
30b 3_C8	Z	-1.0347	-1.0400	0.0300	-0.0300	0.0053	-
30c 3_C8	Z	-1.0329	-1.0400	0.0300	-0.0300	0.0071	-
30d 3_C8	Z	-1.0345	-1.0400	0.0300	-0.0300	0.0055	-
30e 3_C8	Z	-1.0344	-1.0400	0.0300	-0.0300	0.0056	-
30f 3_C8	Z	-1.0341	-1.0400	0.0300	-0.0300	0.0059	-
30g 3_C8	Z	-1.0330	-1.0400	0.0300	-0.0300	0.0070	-
31 4_C5	D	0.4378	0.4375	0.0005	-0.0005	0.0003	--
32 4_C4	X	-10.6928	-10.6900	0.0300	-0.0300	-0.0028	-
33 4_A4	D	0.5626	0.5625	0.0005	-0.0005	0.0001	-
34 4_C4	X	-10.6927	-10.6900	0.0300	-0.0300	-0.0027	-
35 4_C6	R	0.7290	0.7300	0.0300	-0.0300	-0.0010	-
36 4_C8	ResEle	1.9264	1.9300	0.0300	-0.0300	-0.0036	-
37 4_C6	A	67.0004	67.0000	0.5000	-0.5000	0.0004	-
77 2_C2	Y	4.7391	4.7400	0.0300	-0.0300	-0.0009	-
78 2_C2	Y	4.5399	4.5400	0.0300	-0.0300	-0.0001	-
79 2_B2	3d Dist	0.1976	0.2000	0.0300	-0.0300	-0.0024	-
80 2_B3	3d Dist	0.1964	0.2000	0.0300	-0.0300	-0.0036	-
81 2_B4	3d Dist	0.3421	0.3448	0.0300	-0.0300	-0.0027	-
82 2_C3	3d Dist	0.1365	0.1400	0.0300	-0.0300	-0.0035	-
83 2_C4	3d Dist	0.1980	0.2000	0.0300	-0.0300	-0.0020	-
84 2_D4	3d Dist	0.1942	0.2000	0.0300	-0.0300	-0.0058	-
86 3_C6	3d Dist	0.2012	0.2000	0.0300	-0.0300	0.0012	-
88 3_C5	Z	0.2555	0.2500	0.0300	-0.0300	0.0055	-
89 3_C2	CartDist	1.0619	1.0600	0.0100	-0.0100	0.0019	-
92 4_D2	Z	1.2570	1.2550	0.0100	-0.0100	0.0020	-
93 4_D2	Z	1.2571	1.2550	0.0100	-0.0100	0.0021	-
96 5_D8	3d Dist	0.1710	0.1692	0.0300	-0.0300	0.0018	-



Customer Dart Aerospace

Customer P.O. PO22776

Drawing # E4706

Drawing rev A

Part Number E4706-1

E.C.O. -

Part Name Support Bracket

Material Alum. Alloy 7075-T7351 per ASTM B209

Serial # 005

Inspected by Cliff Smith

Job # 36656

Signature:



Overall Result

All Characteristics: 35
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Comment: Side 2

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<-- -->
38 4_D2	Z	-1.2572	-1.2600	0.0300	-0.0300	0.0028	-
top and bott surfs Parallel ref	GDT Par	0.0012	0.0000	0.0100		0.0012	-
39 4_B6	D	0.6254	0.6250	0.0005	-0.0005	0.0004	--
40 4_C3	X	-3.6378	-3.6400	0.0300	-0.0300	0.0022	-
41 4_D4	D	0.5000	0.5000	0.0005	-0.0005	0.0000	-
42 4_C3	X	-3.6381	-3.6400	0.0300	-0.0300	0.0019	-
42 4_D4	R	0.7300	0.7300	0.0300	-0.0300	0.0000	-
43 4_D2	ResEle	1.8924	1.8900	0.0300	-0.0300	0.0024	-
44 4_D3	A	67.0152	67.0000	0.5000	-0.5000	0.0152	-
45 4_D2	ResEle	5.0762	5.0800	0.0300	-0.0300	-0.0038	-
46 5_B2	Y	1.6541	1.6500	0.0300	-0.0300	0.0041	-
47 5_B2	Y	1.9648	1.9600	0.0100	-0.0100	0.0048	--
48 5_C2	Y	2.8915	2.8900	0.0300	-0.0300	0.0015	-
49 5_B2	Y	2.5815	2.5800	0.0100	-0.0100	0.0015	-
47 Perp to body surf ref	GDT Perp	0.0005	0.0000	0.0050		0.0005	-
49 Parallel to 47 ref	GDT Par	0.0007	0.0000	0.0060		0.0007	-
50 5_B2	Y	1.3121	1.3100	0.0300	-0.0300	0.0021	-
51 5_C2	Y	3.2338	3.2300	0.0300	-0.0300	0.0038	-
52 5_B3	X	-2.4451	-2.4500	0.0300	-0.0300	0.0049	-
53 5_B4	X	-4.3653	-4.3700	0.0300	-0.0300	0.0047	-
54 5_B6	X	-9.5002	-9.5000	0.0300	-0.0300	-0.0002	-
55 5_B6	X	-9.7230	-9.7200	0.0300	-0.0300	-0.0030	-
56 5_B6	X	-11.1982	-11.2000	0.0300	-0.0300	0.0018	-
57 5_B8	Y	1.5877	1.5900	0.0300	-0.0300	-0.0023	-
58 5_C8	Y	3.6181	3.6200	0.0300	-0.0300	-0.0019	-
59 5_D8	Y	1.8711	1.8700	0.0300	-0.0300	0.0011	-
60 5_C8	Y	3.3462	3.3400	0.0300	-0.0300	0.0062	-
61 5_D6	Z	-0.9833	-0.9900	0.0300	-0.0300	0.0067	-
62 5_B8	Y	2.2065	2.2100	0.0300	-0.0300	-0.0035	-
63 5_C8	Y	3.0037	3.0100	0.0300	-0.0300	-0.0063	-
90 3_B5	Z	0.2181	0.2150	0.0300	-0.0300	0.0031	-
91 3_B2	CartDist	1.2381	1.2400	0.0100	-0.0100	-0.0019	-

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
94 4_D2	Z	1.2250	1.2200	0.0100	-0.0100	0.0050	-
95 4_D2	Z	1.2219	1.2200	0.0100	-0.0100	0.0019	-

Manually Inspected Features

64	2_B3	R0.28 typ.	<u>R.28 TYP.</u>
65	3_C8	R0.25 typ.	<u>R.25 TYP.</u>
66	3_B5	R0.06 typ.	<u>R.09 TYP.</u>
67	3_B2	R0.14 typ.	<u>R.14 TYP.</u>
68	4_D4	R0.22	<u>R.22 TYP.</u>
69	5_D7	R0.25 min.	<u>R.25 TYP.</u>
70	5_C5	R0.28 4 pl.	<u>R.28 TYP.</u>
71	5_A8	15.25 ref.	<u>15.25</u>
72	2_A8	Deburring per note 5	<u>O.K.</u>
73	2_A8	Surface finish per note 8	<u>≤ 65 Ra</u>
74	2_A8	Relief parallel to outside face	<u>O.K.</u>
75	2_A3	0.20 dim	<u>-203</u>
76	2_D3	0.32 dim	<u>.314</u>
85	2_B4	R0.28 typ.	<u>R.28 TYP.</u>
86	3_C5	0.20 wall	<u>-200/.201</u>
87	3_B8	0.23 wall typ.	<u>-223/.224</u>

